

Friday, 12/9/2005 12:06:41 PM
Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPAD
Job Number :	25194		
Estimate Number :	11355		
P.O. Number :	N/A	Part Number :	D334015
This Issue :	12/9/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3340 REV B
First Issue :	12/9/2005	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	B
	Type :	Material :	N/A
	PURCHASED PARTS	Due Date :	12/30/2005
Written By :	<i>SEE COMMENT BELOW</i>		Qty: 20 Um: Each
Checked & Approved By :	<i>SEE ABOVE DATE & USE</i>		
Comment :	Est: A 05.11.10 Preliminary issue AP/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: 000000267

Email of ship DXF file to vendor

Laser Cut per Dwg D3340 flat pattern D3340-15

Material release note required

AP
05/12/12

2.0

D334015F

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
Wearshoe

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

C206162102

(20)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimensions

Jan 05
(20)

5.0

BRAKE NC

NC BRAKE

**Comment:** NC BRAKE

Deburr if necessary

Form on brake as per Dwg D3340 using Jigs DT

and DT

SB

06/02/17
(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/25

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/9/2005 12:06:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 25194

Part Number: D334015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-02-17

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

MDL 06/03/21

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MDL 06-03-22

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 364

MDL 4/3/22

(20)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

MDL 06/03/23

(20)

Job Completion



MDL 06-03-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

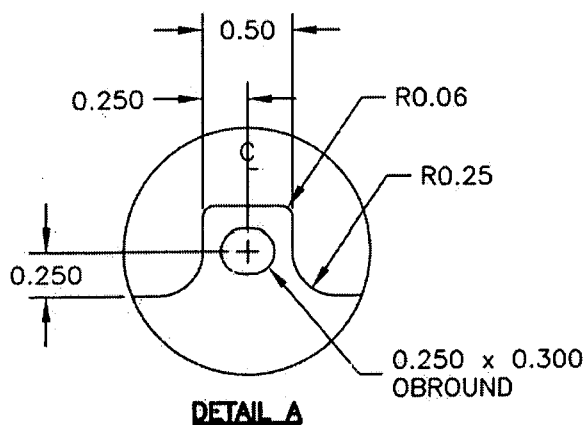
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

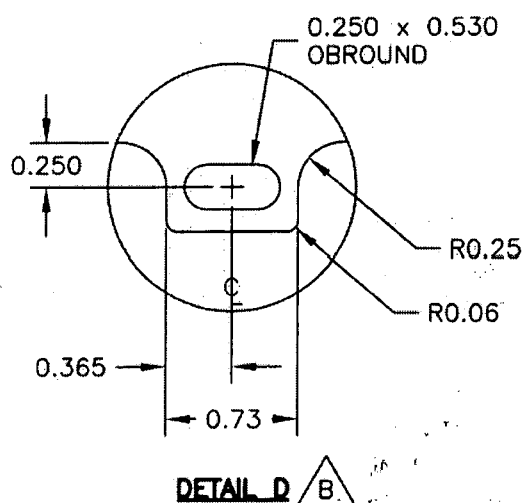
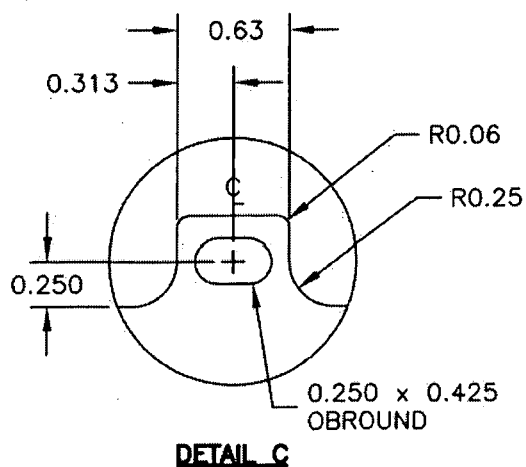
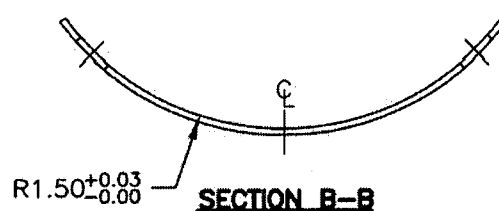
NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



RELEASED
05.11.28



WORK ORDER
NO. 25194

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TEST CERTIFICATE

Ref: 500521329

CUSTOMER	Willsons	P41007bI002	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC107796																					
CUSTOMER Q/N	90-10N-288		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																					
ROLL Q/N	453665		DIMENSIONS	6.031" x 48" x Coil	DATE	11 March 2005																					
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT										MECHANICAL TESTS (TEST SPECIFICATION - ASTMA170)															
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE	BEND 180°	YIELD	T.S.	WELONG G.L.=	HARDNESS HRB	r ()	LENGTH (feet)			
		x100				x1000										x10000		x100									
R9-455932-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2621			
R9-455933-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2723			
R9-455934-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2546			
R9-455935-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2789			

P/O 267

2602-05

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=6.65 ± 50 (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r4S (B)=r90 (D)=(r0+r90+2r4S)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
 QC METALLURGIST

20 GA CRMS